

Split -1

Work Order ID 89808 -2

89808

Page 1

September-10-12 8:05:34 AM

Item ID: D3564-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearshoe

Start Date: 9/10/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 9/21/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: 1.1 Prog
Rev: 1.1 2-Debur if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

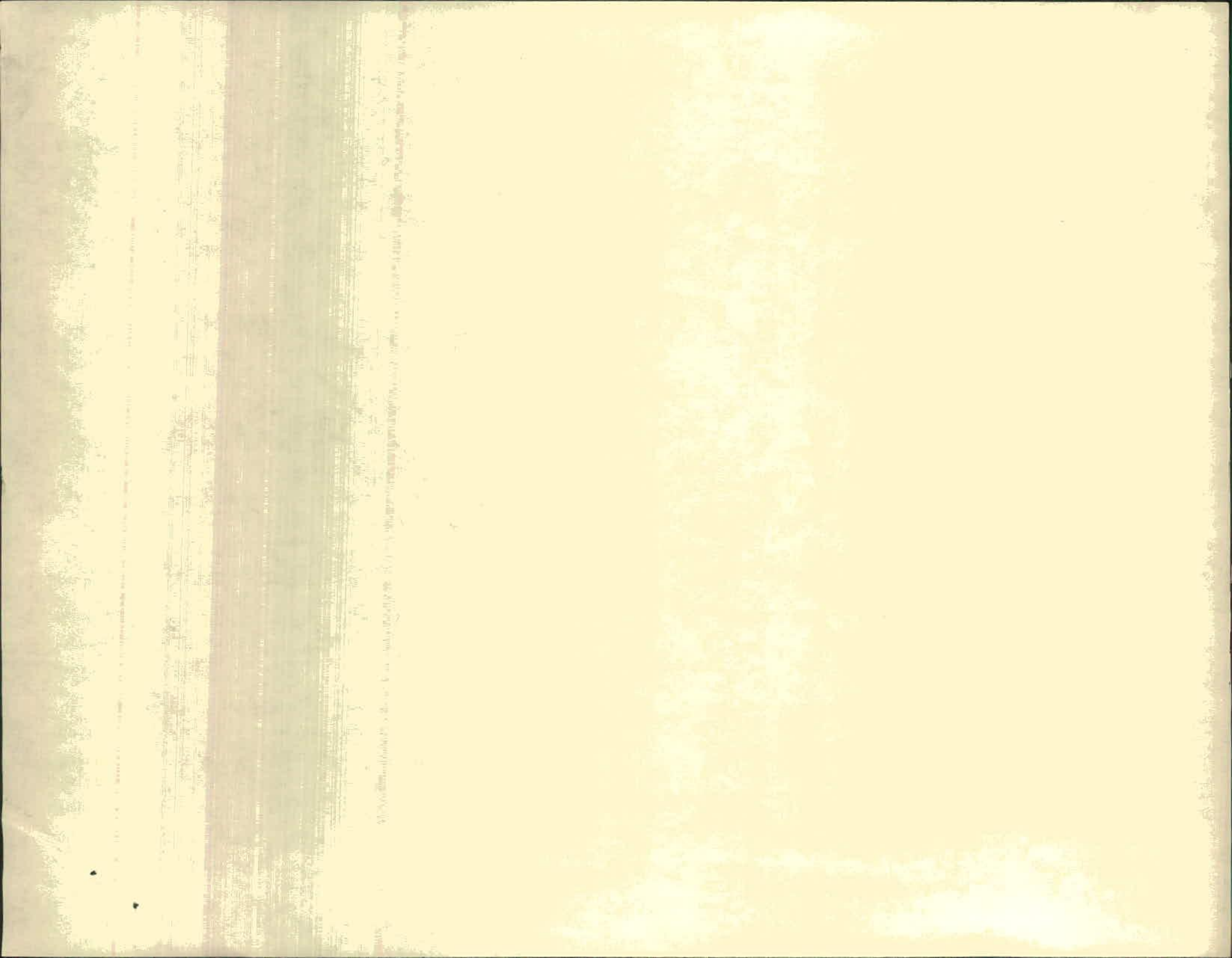
120

QC

Memo

0.00

Quality Control



Work Order ID 89808

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Page 2

Item ID: D3564-11

Accept

N900040100

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Revision ID:

Stop *NS2*

Item Name: Wearshoe

Start Date: 9/10/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 9/21/12 Req'd Qty: 16.00

16

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

Memo

0.00

0.00

Brake NC

Debur if necessary Form on Brake as per Dwg D3564 using Jigs DT8179

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150

150

Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Qty Description Batch A/R 2059B Hardcoat
m122879 Weld hardcoat as per Dwg D3437

8

EL 12-1-15

Work Order ID 89808

89808

Page 3

September-10-12 8:05:34 AM

Item ID: D3564-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearshoe

Start Date: 9/10/12

Start Qty: 16.00

16

Cust Item ID:

Required Date: 9/21/12

Req'd Qty: 16.00

16

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Quality Control

Memo

0.00

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Quality Control

Memo

0.00

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

m122966

3200F

1-30

8X

m/f
12/11/21

DAS
16
12/1/15

DAS
17
12/1/15

70

Work Order ID 89808

September-10-12 8:05:34 AM

89808

Page 4

Item ID: D3564-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearshoe

Stop *NS2*

Start Date: 9/10/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 9/21/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: F-P1

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

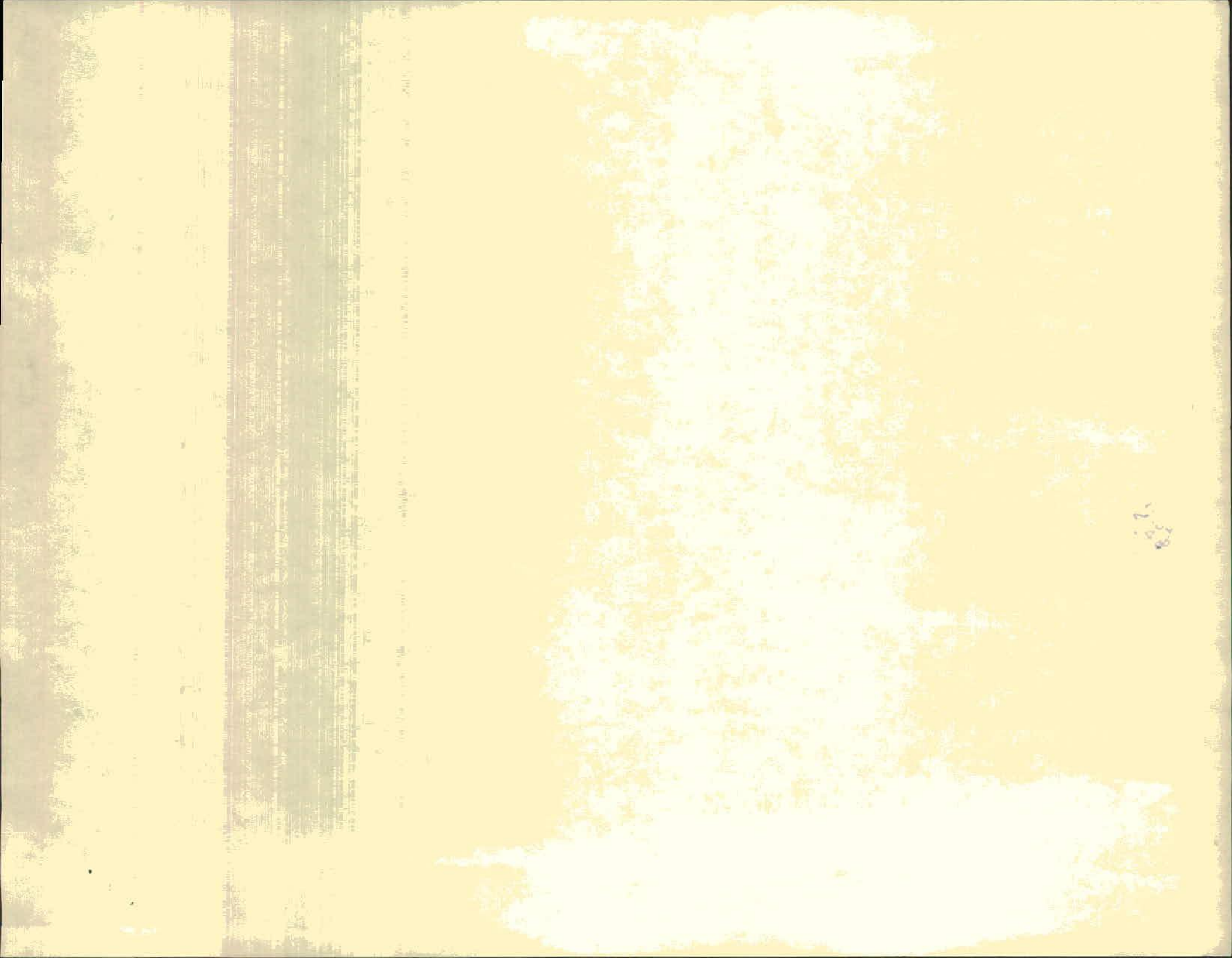
0.00

Quality Control

8 φ 12-11-21

8xφ m/f 12/11/21

12/11/22
mf
12-11-22



Picklist Print

September 10-12 8:05:34 AM

Page 1

Work Order ID: 89808

Parent Item: D3564-11

Parent Item Name: Wearshoe

Start Date: 9/10/12

Required Date: 9/21/12

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	231.2280	1.41	23.747368			

0312-09-10

Location

Loc Qty

Loc Code

MAT020

231.228

122245

56.778

122321

1.2

122753




173.25

122753

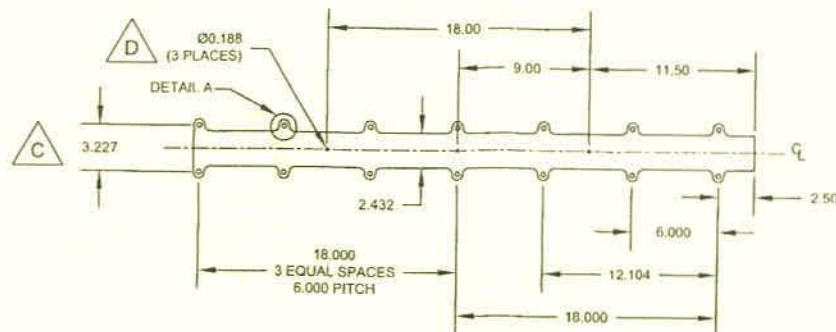
DART AEROSPACE LTD		Work Order:	84800
Description: Wearshoe		Part Number:	D3504-11
Inspection Dwg: D3564	Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: 	Audited by: 	Prototype Approval: N/A
Date: 	Date: 	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	

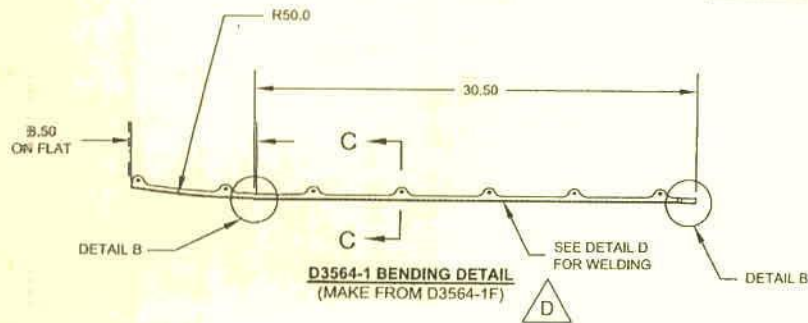


D3564-1F FLAT PATTERN

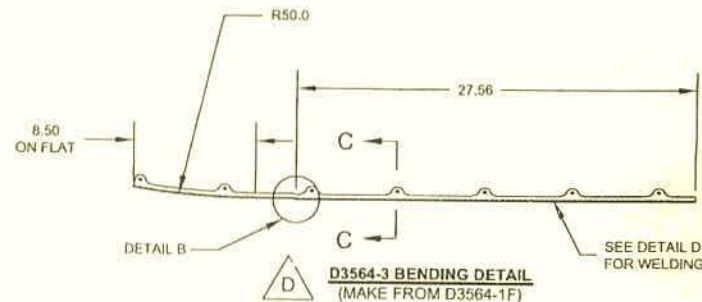
RELEASED

07.09.04

UNDER REVIEW
F-104
Trans change
OK 11.11.23



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

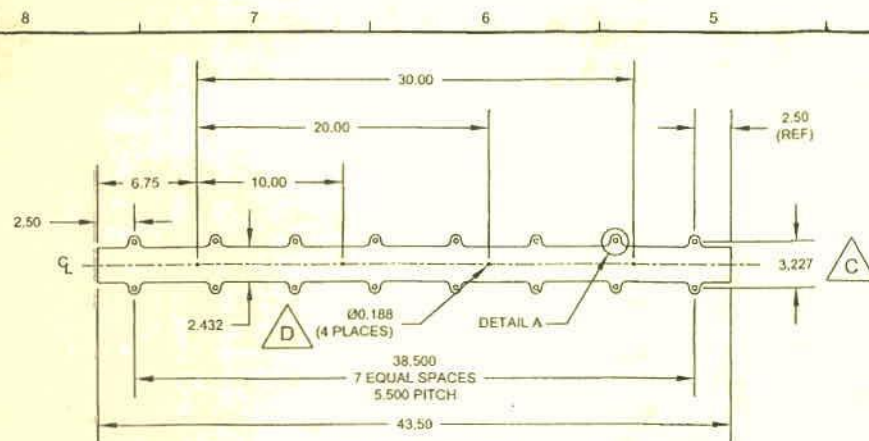
D3564-1/3/5/7/9/11/13/15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR: AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNIT: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE FIG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRICAL ABOUT CL

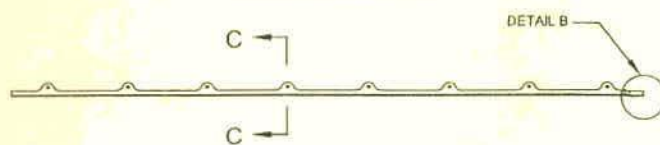
WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

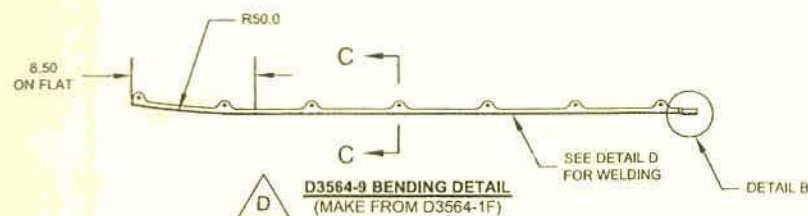
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.13
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3564		REV. D	
TITLE WEARSHOE		SHEET 1 OF 3	
SCALE 1:8			
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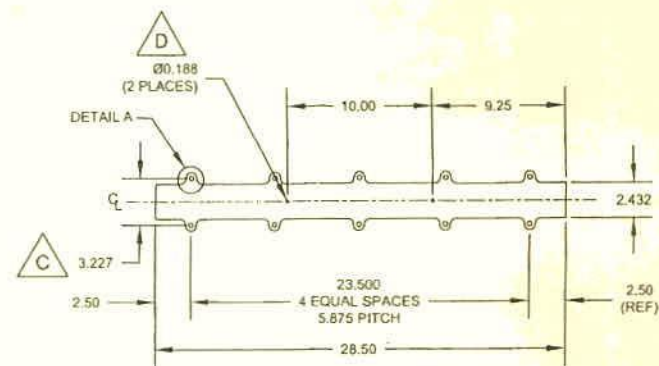
D3564-5F FLAT PATTERN



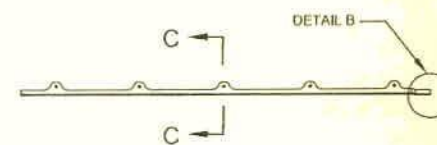
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



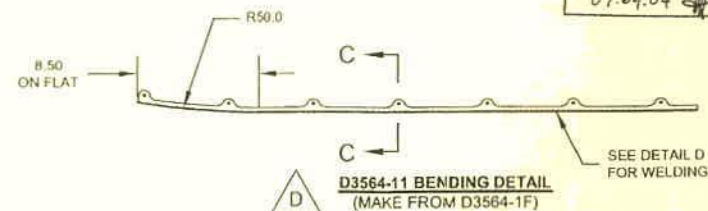
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



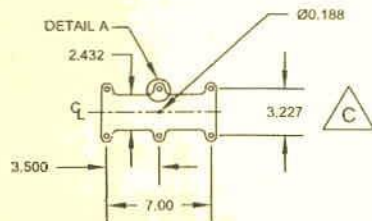
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

UNDER REVIEW
OK 11.1.28

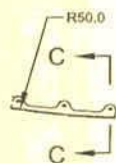
RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG APPR	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR	PH	WEARSHOE	5:8
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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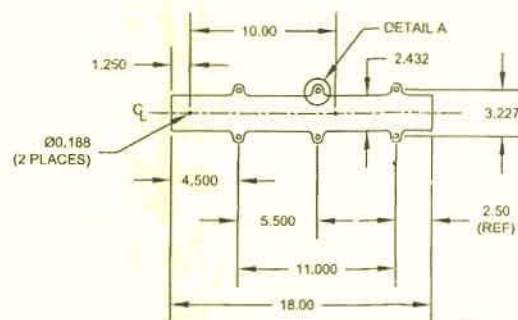
8 7 6 5 4 3 2 1



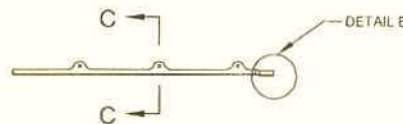
D3564-13F FLAT PATTERN



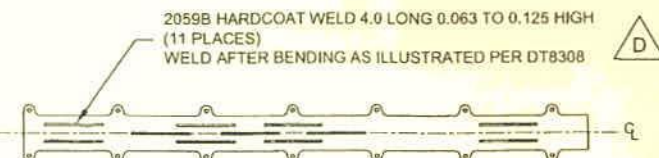
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



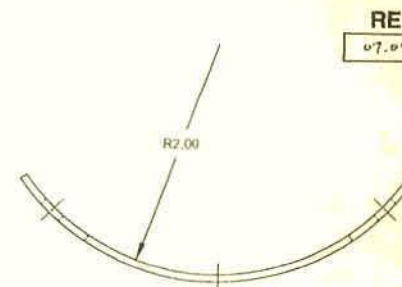
D3564-15F FLAT PATTERN



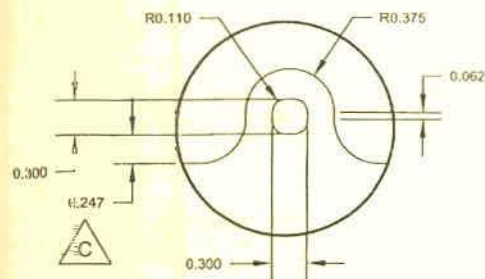
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



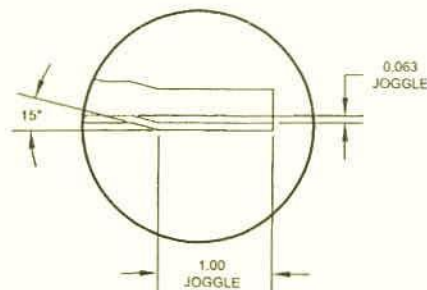
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

RELEASED
07.07.04

UNDER REVIEW
OK 07.11.28

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
MFG. APPR	PH	SHEET 3 OF 3	
APPROVED	PH	TITLE WEARSHOE	SCALE 1:8
DE APPR	PH	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

